


Date: Thursday, 4/20/2006 9:57:00 AM  
User: Linda Lacelle



# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
<b>Job Number</b> : 23238	
<b>Estimate Number</b> : 10007	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D205596101
<b>This Issue</b> : 4/20/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D205-596-101 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : NIA
<b>First Issue</b> : 11/14/2005 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 23804	<b>Material</b> : NIA
<b>Written By</b> : 	<b>Due Date</b> : 4/14/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est Rev G Removed Bending 05-10-25 JLM	

## Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL  
Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

2.0	D2889	FWD Crosstube
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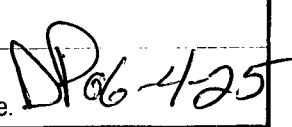
 

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
FWD Crosstube  
Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	B22533 DP06-4-25

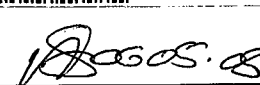
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1  
2- Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template. 

4.0	QC6	DIMENSIONAL CHECK
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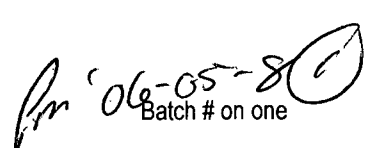
**Comment:** DIMENSIONAL CHECK  
Conformity check and sign off by engineering. 

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101 

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube. 

Batch # on one

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:57:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 23238

Part Number: D205596101

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*pm 06-05-26 (1)*



Comment: HAND FINISHING RESOURCE #1

*Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-05-31 (1)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*06-08-18 (1)*



Comment: HAND FINISHING RESOURCE #1

Prime inside and outside with Immron per QSI 005 4.2

*06-08-21 (1)*

9.0

QC14

Inspect Spray Paint



*06-08-22 (1)*



Comment: Inspect Spray Paint

10.0

D2856600

Abrasion Strip



Comment: Qty.: 0.7080 f(s)/Unit Total : 0.7080 f(s)

Abrasion Strip

Pick:

Qty Part number

Description

Batch

2

D2856-600-851 Abrasion Strip

*824328*

*RT*

*06-08-28*

11.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Pick:

Qty Part number Description

Batch

2

D2893-1

Support

*824775*

*RT*

*06-08-28*

12.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4

MS21920-24

Clamp

*819349*

*RT*

*06-08-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/08/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:57:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 23238

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg  
D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

25 06-08-28

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-8-29

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location: \_\_\_\_\_

Rev K

4/8/29 (1)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

25 06/08/30 (1)

Job Completion



25 06/08/30

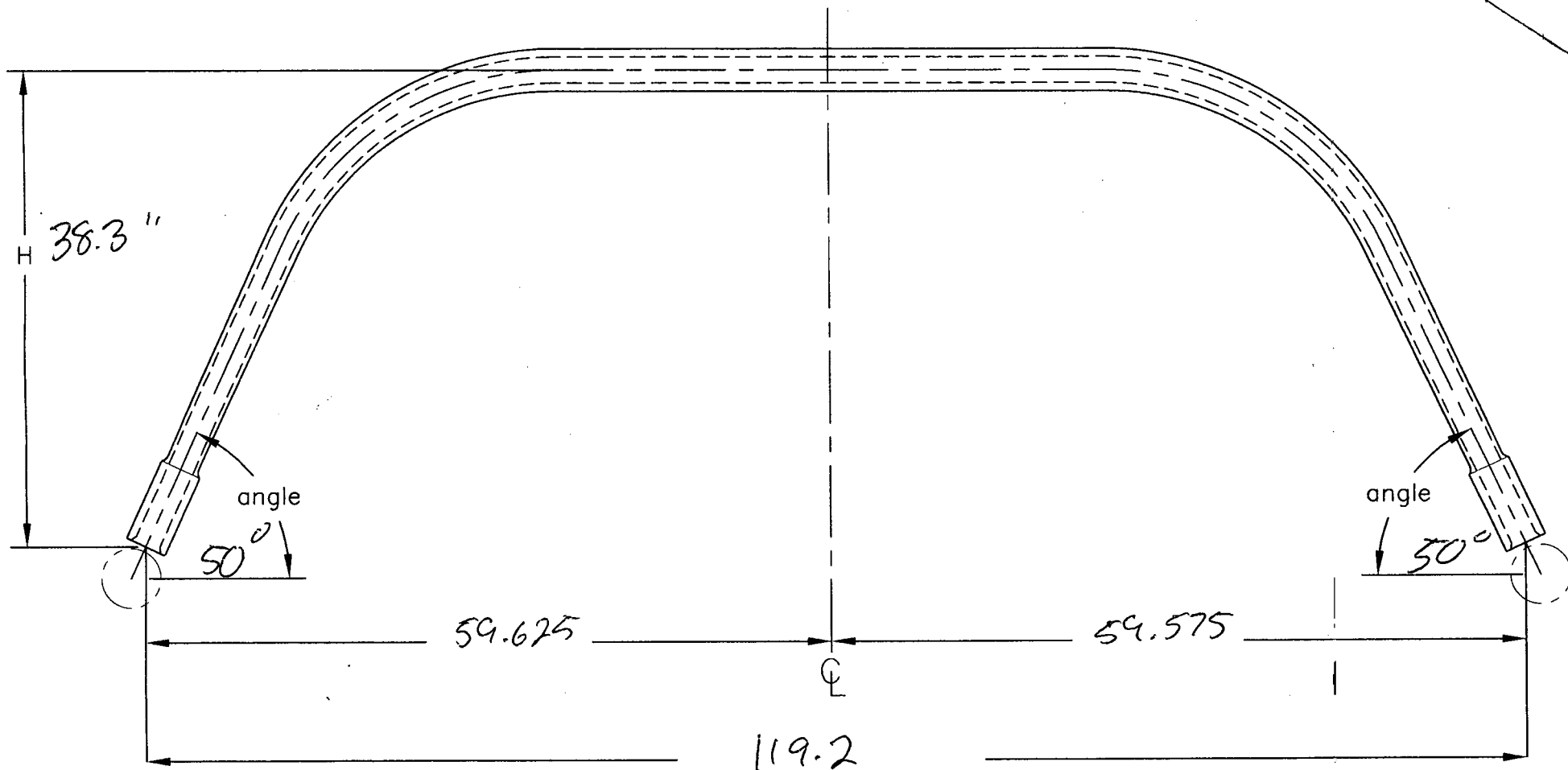
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DATE: 06-05-04

DESCRIPTION: D205-596-101

BATCH NO: 23238

DRAWING: D205-596-101 Rev A

H: 38.3'

1/2 SPAN: 59.6'

TOTAL SPAN: 119.2'

ANGLE: 50'

*Handwritten signature*